

Work Order ID 75183

75183

Page 1

October-18-11 2:53:33 PM

Item ID: D3319-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Wearplate
 Start Date: 18/10/2011 Start Qty: 12.00 ***12*** Cust Item ID:
 Required Date: 04/11/2011 Req'd Qty: 12.00 ***12*** Customer:
 Reference:

Approvals: Process Plan: M.C. 5 Date: 11/10/18 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3319	Rev B								

100 FLOW WATER JET 0.00
100
 Waterjet Memo 0.00
 FLOW CNC Waterjet 1-Cut as per Dwg D3319
 1010 .048 Dwg Rev: B
 Prog Rev: B
 2-Deburr if necessary
 110 QC2- Inspect parts off machine FAI/FAIB 0.00
110
 QC Memo 0.00
 Quality Control
 120 QC8- Inspect parts - second check 0.00
120
 QC Memo 0.00
 Quality Control

18-10-28
18-10-28
7/12

(12)

8/10/28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	NC BRAKE	0.00							
140									
Brake NC	Memo	0.00							
Brake NC	1- Form using DT8326 & DT8261 as per Dwg D3319 Rev: <u>B</u>								
	2- Form flat on press using DT8776 block								
150	QC6- Inspect dimensions to drawing	0.00							
150									
QC	Memo	0.00							
Quality Control									
160	Weld per dwg A/R Hardcoat steel Batch: _____	0.00							
160									
Large Fab	Large Fab	0.00							
Large Fab	Memo								
	1- Layout weld location as per Dwg D3319 using jig D3319-1T3								
	2- Weld hard surface using DT8755 per QSI 004 and Dwg D3319 Rev: <u>B</u>								
	Qty Part Number Description Batch								
	A/R N/A 228/7560 Hardcoat Rod <u>M117741</u>								

R _____
m 11 10 31 (12)
(12) MAY/12 11/11/21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Page 3

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Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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170	QC10- Inspect visual per QSI004- ground welds	0.00							
170		0.00							
QC	Memo								
Quality Control									

180	QC5- Inspect part completeness to step on W/O	0.00							
180		0.00							
QC	Memo								
Quality Control									

190	Grey Sandtex(Ref.4.3.5.6) per QSI005 4.3	0.00							
190									
Powdercoat	Memo								
Powder Coating									

START TIME: 11:40
OVEN TEMPERATURE: 320 °F
FINISH TIME: 12:10

M118489

12x6 M-11/11/22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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October-18-11 2:53:33 PM

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Page 4

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QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

200	QC3- Inspect Part Finish	0.00							
-----	--------------------------	------	--	--	--	--	--	--	--

200QC
Quality Control

Memo

0.00

12 BL 11-11-22

210

210

Packaging

Packaging

Packaging

Memo

Identify on inside surface using a permanent fine point marker with the following:
TCCA-PDA, Dart Aerospace Ltd.
P/N: D3319-1, B/N: BXXXXX
For Product Eligibility see PDA05-18 and Stock
Location: 497

0.00

0.00

11/11/23 SP (12)

220

220

QC

Quality Control

QC21- Final Inspection - Work Order Release

Memo

0.00

0.00

11/11/23 MF11-11-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Picklist Print

October-18-11 2:53:38 PM

Page 1

75183

D3319-1

Work Order ID: 75183

Parent Item: D3319-1

Parent Item Name: Wearplate

Start Date: 18/10/2011

Required Date: 04/11/2011

Start Qty: 12.00

Required Qty: 12.00

Comments:

IPP: B05.10.14Added step 9, dwg rev B KJ/EC

IPP Rev:C Now on Waterjet 06-10-26 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M1010S18GA		Purchased		No		100	sf	287.3000	0.628	7.932632			

M1010S18GA

1010/1025 SHEET .048

**

1811-10-28

Location

Loc Qty

Loc Code

MAT019

287.3

116268

21.5

117806

265.8

117806

12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	75183
Description: Wearplate		Part Number:	D3319-1
Inspection Dwg: D3319 Rev: B		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

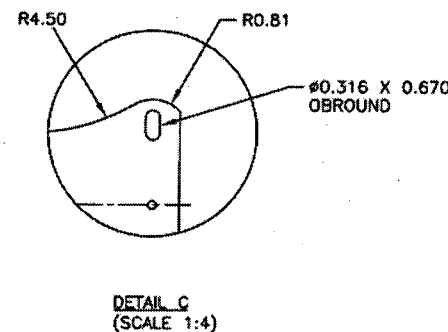
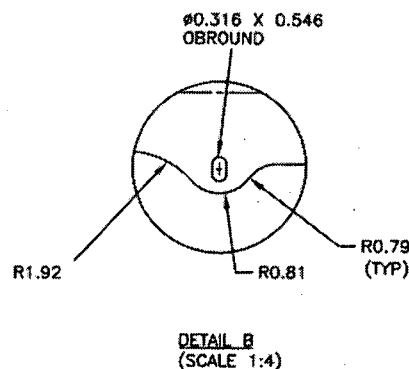
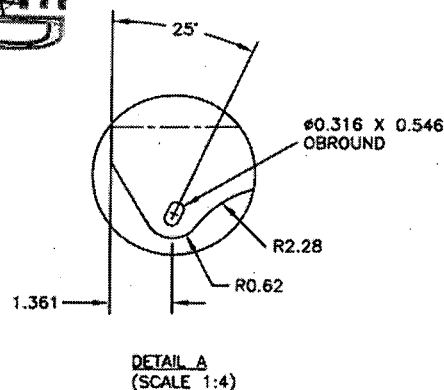
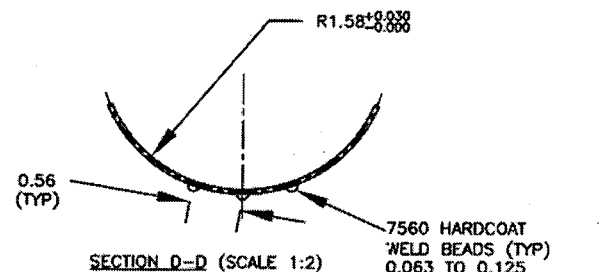
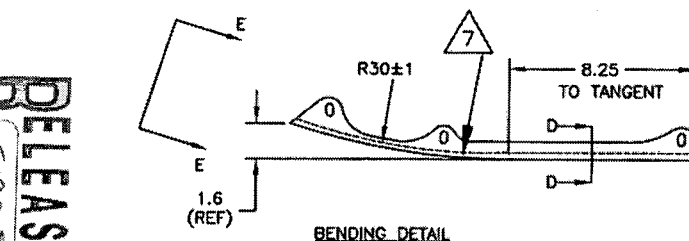
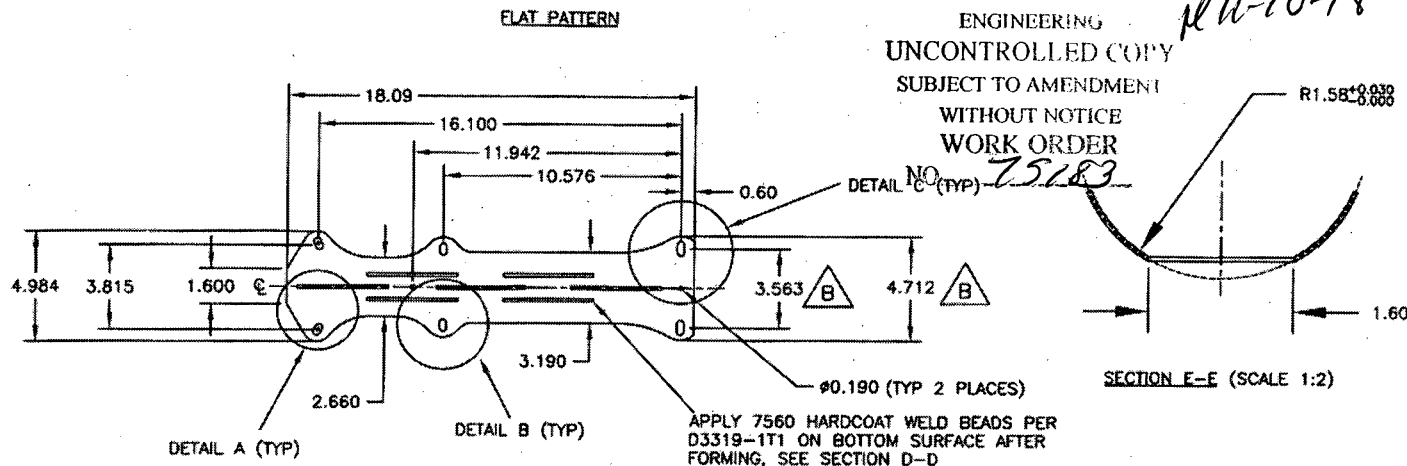
☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.984	+/-0.010	4.981	2		V H302	
1.600	+/-0.010	1.600	2		V	
2.660	+/-0.010	2.662	2		V	
3.190	+/-0.010	3.195	2		V	
3.563	+/-0.010	3.561	2		V	
4.712	+/-0.010	4.709	2		V	
0.60	+/-0.030	0.60	2		V	
10.576	+/-0.010	10.576	2		T 1B01	
11.942	+/-0.010	11.942			T	
18.09	+/-0.030	18.09	2		T	
Ø0.316 x 0.546	+0.006/-0.001 x +/-0.010	316 x 548	2		V	
Ø0.316 x 0.670	+0.006/-0.001 x +/-0.010	315 x 675	2		V	
Ø0.190	+0.005/-0.001	.191	2		V	

Measured by: B	Audited by: S	Prototype Approval:	N/A
Date: 11-10-28	Date: 11/10/28	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.05.31	New Issue	KJ/JLM	

RELEASED
05-09-30



D3319-1 WEARPLATE

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK)
- 2) FINISH: POWDER COAT GREY SANDEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) PART IS SYMMETRICAL ABOUT CENTERLINE
- 5) ALL DIMENSIONS IN INCHES
- 6) WELD PER DART QSI 004
- 7) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER:
"TCCA-PDA, DART AEROSPACE LTD., P/N D3319-1 B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-18"

SHOP COPY

RETURN TO

ENGINEERING

UNCONTROLLED COPY

SUBJECT TO AMENDMENT

WITHOUT NOTICE

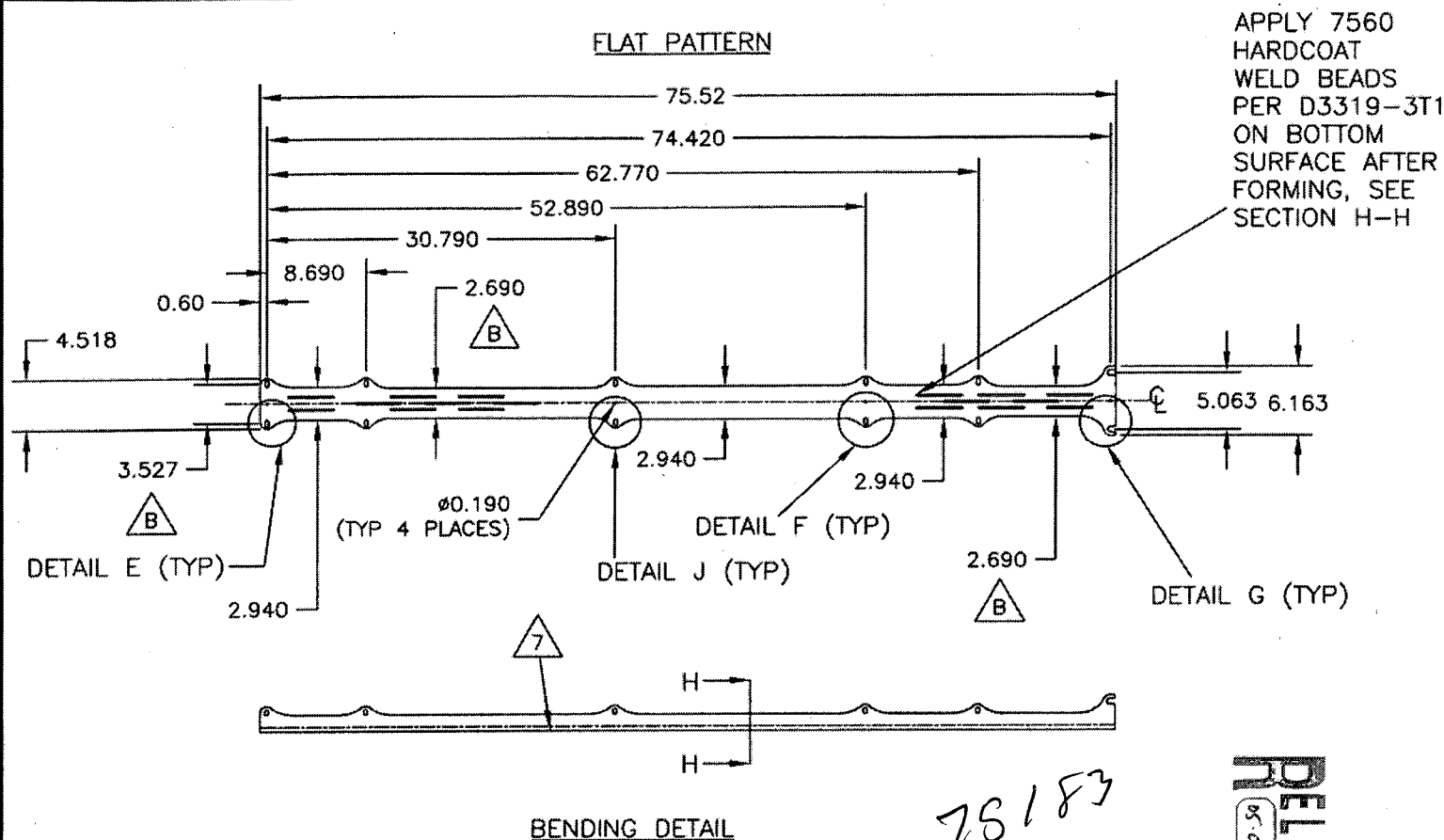
WORK ORDER

NO. 75183

11-10-18



DESIGN	DRAWN BY	DART AEROSPACE LTD
P1	04	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
		D3319
DATE	TITLE	REV. B
05.06.06	WEARPLATE	SHEET 1 OF 5
A	04.09.24	NEW ISSUE
B	05.06.06	WIDEN HOLES, REDUCE WIDTH -3/-5/-7
		SCALE 1:8



D3319-3 WEARPLATE

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) PART IS SYMMETRICAL ABOUT CENTERLINE
- 5) ALL DIMENSIONS IN INCHES
- 6) WELD PER DART QSI 004
- 7) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER:
"TCCA-PDA, DART AEROSPACE LTD., P/N D3319-3 B/N BXXXXX,
FOR PRODUCT ELIGIBILITY SEE PDA05-18"



DESIGN	D3319	DRAWING NO.	D3319	REV. B
CHECKED	[Signature]	APPROVED	[Signature]	SHEET 2 OF 5
DATE	05.06.06	TITLE	WEARPLATE	SCALE
				1:15

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

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- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21,
38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) PART IS SYMMETRICAL ABOUT CENTERLINE
- 5) ALL DIMENSIONS IN INCHES
- 6) WELD PER DART QSI 004
- 7) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER:
"TCCA-PDA, DART AEROSPACE LTD., P/N D3319-5 B/N BXXXXX,
FOR PRODUCT ELIGIBILITY SEE PDA05-18"

75183

05-09-30

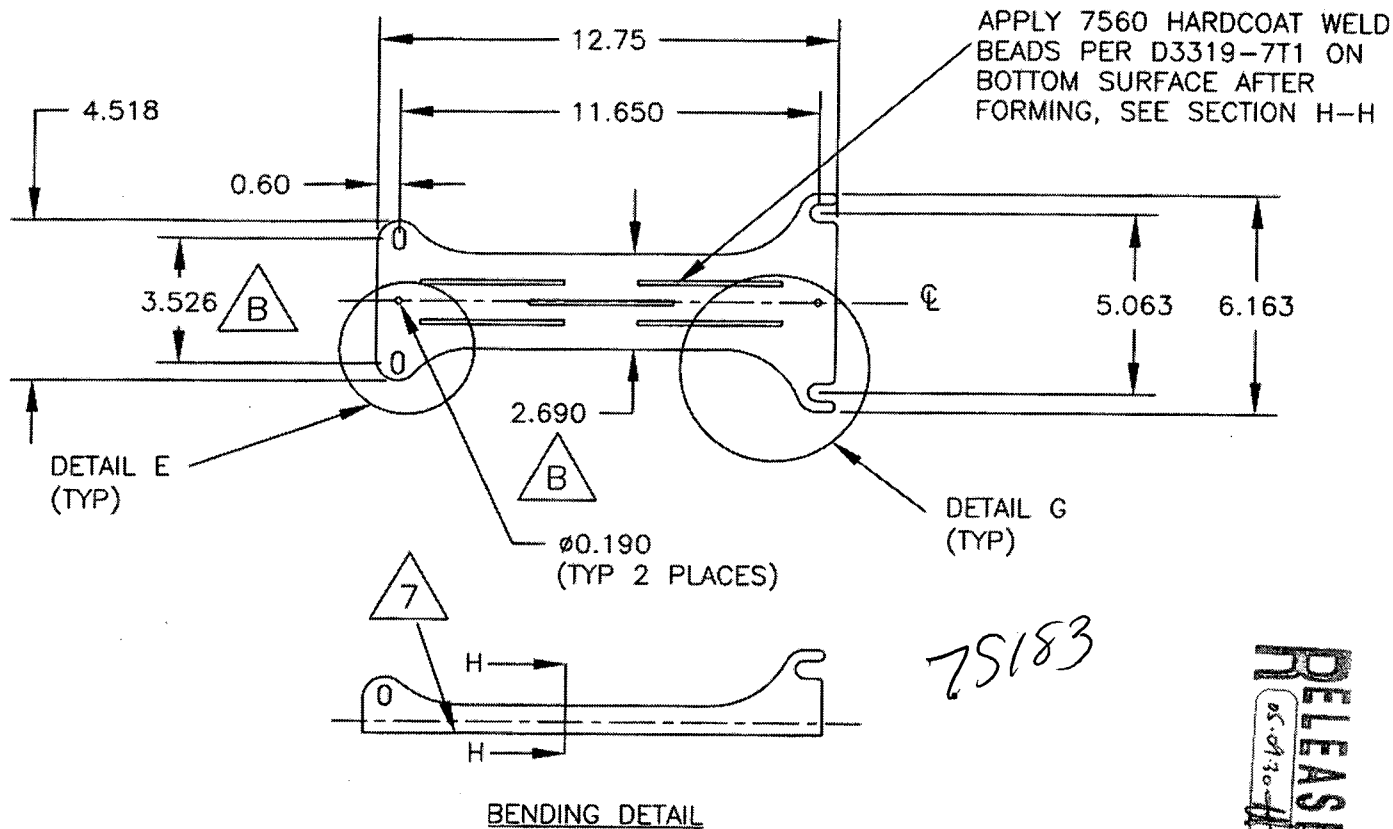
DART

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041		041		HAMKESBURT, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.		REV. B	
#	#	D3319		SHEET 3 OF 5	
DATE		TITLE		SCALE	
05.06.06		WEARPLATE		1:5	



DESIGN	PH	DRAWN BY	PH	DART AEROSPACE LTD
CHECKED	PH	APPROVED	PH	HANESBURY, ONTARIO, CANADA
DATE	05.06.06	TITLE	D3319	REV. B
			WEARPLATE	SHEET 4 OF 5
				SCALE 1:5

FLAT PATTERN



D3319-7 WEARPLATE

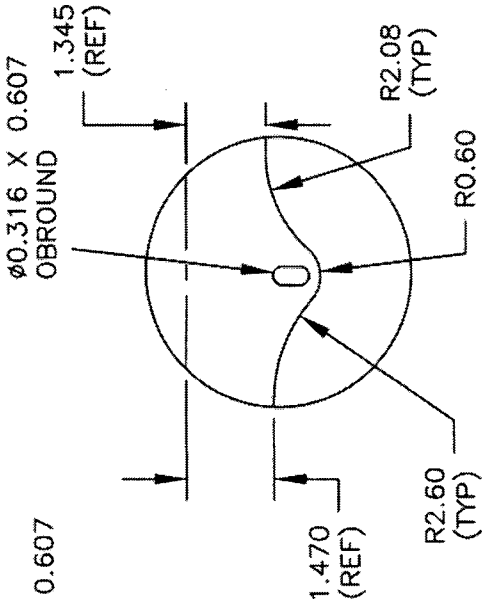
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"TCCA-PDA, DART AEROSPACE LTD., P/N D3319-7 B/N BXXXXX,
FOR PRODUCT ELIGIBILITY SEE PDA05-18"



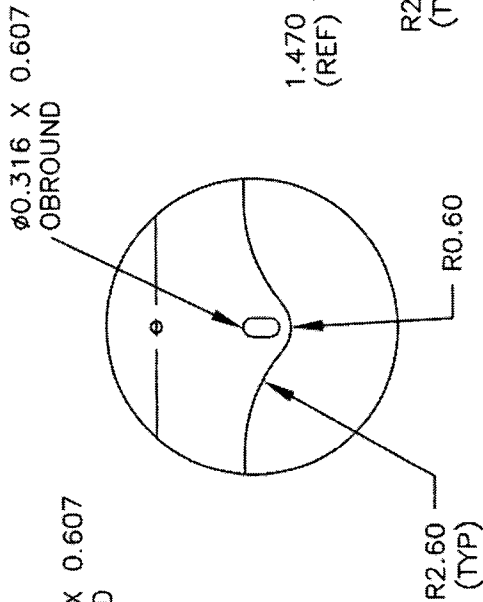
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CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3319	REV. B SHEET 5 OF 5
DATE 05.06.06	TITLE WEARPLATE		SCALE 1:3

RELEASED
05-09-30

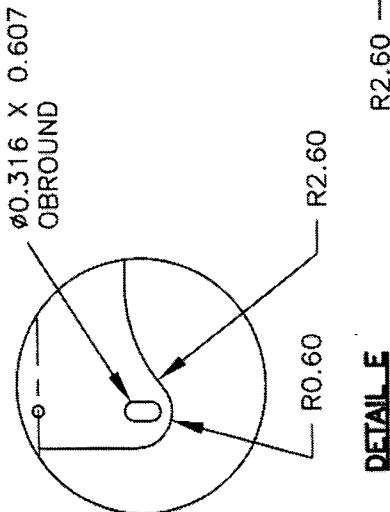
75183



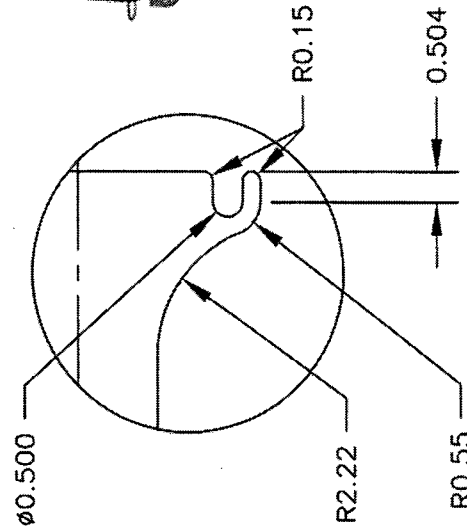
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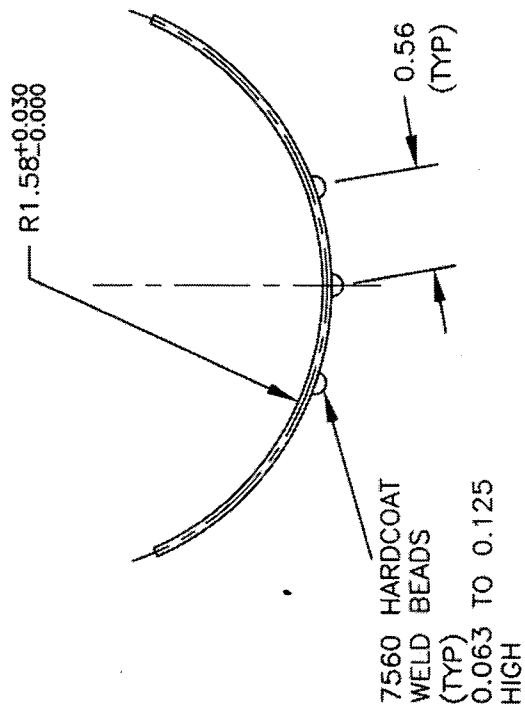
DETAIL F



DETAIL E



DETAIL G



SECTION H-H
(SCALE 1:1)

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